

Work Order ID 81563

81563

Page 1

March-15-12 12:44:12 PM

Item ID: D350-607-047A

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 15/03/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 13/04/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/03/15 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D350-607-1	A

100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPPD350-607-047A CHG001								

110	Pick Kit	0.00							
-----	----------	------	--	--	--	--	--	--	--

110									
Packaging	Memo	0.00							
Packaging									

120	Small Fab	0.00							
-----	-----------	------	--	--	--	--	--	--	--

120									
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D350-607								



SP *12-04-16*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81563***81563***

Page 2

March-15-12 12:44:12 PM

Item ID: D350-607-047A

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Stop ***NS2***

Start Date: 15/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 13/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

Sizley 16

140

Pick Kit

0.00

140

Packaging

Memo

0.00

Packaging

12/4/16 SP

150

QC4- 100% Inspect kits for completeness

0.00

150

QC

Memo

0.00

Quality Control

Sizley 16

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81563***81563***

Page 3

March-15-12 12:44:12 PM

Item ID: D350-607-047A

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 15/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 13/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00

160

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-607-047A
Location: _____

12/4/16

170

0.00

170

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

12/4/17

mf
12-04-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

March-15-12 12:44:19 PM

Page 1

Work Order ID: 81563

81563

Parent Item: D350-607-047A

D350-607-047A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: New issue DD verified by:EC
as per ecn 10-545 DD 10.04.19 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D350-607-241

46701

Manufactured

No

140

Each

2.0000

1

1

D350-607-241

Basket Clamp Assembly

**

B8342 SP

Location

Loc Qty

Loc Code

PKG12

-3

80920

2

PKG13

5

D2022-101

Manufactured

No

110

Each

181.0000

5

5

D2022-101

Spacer

**

SP

Location

Loc Qty

Loc Code

ST504

181

73307

4

77047

60

79465

117

5x

D2258-200

Manufactured

No

110

Each

3.0000

1

1

D2258-200

Placard 200lb

**

B81888 SP

D-04-11a

Location

Loc Qty

Loc Code

ST505

3

71180

3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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March-15-12 12:44:19 PM

Work Order ID: 81563

81563

Parent Item: D350-607-047A

D350-607-047A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2530 Manufactured No

110 Each 8.0000 1 1

D2530

Handle Weldment

**

B82150 8p

Location

Loc Qty

Loc Code

ST506

8

77030

2

78965

6

D2535 Manufactured No

110 Each 42.0000 2 2

D2535

Spring

**

8p

Location

Loc Qty

Loc Code

ST504

42

77488

42

2x

D2537 Manufactured No

110 Each 32.0000 2 2

D2537

Bushing

**

8p

Location

Loc Qty

Loc Code

ST504

32

77055

32

2x

D2931 Manufactured No

110 Each 496.0000 2 2

D2931

Bumper

**

8p

Location

Loc Qty

Loc Code

ST504

496

46064

496

2x

D3265-041 Manufactured No

110 Each 0.0000 1 1

D3265-041

Basket Base Assembly

**

B81570

Ep 12/04/16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 81563

81563

Parent Item: D350-607-047A

D350-607-047A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3267-041 Manufactured No

110 Each 0.0000 1 1

D3267-041

Basket lid Assembly (Outside)

B 81566 (1x) **

SP 12/04/16

D3267-043 Manufactured No

110 Each 0.0000 1 1

D3267-043

Basket Lid Assembly (Inside)

B 81567 (1x) **

SP 12/04/16

D350-607-143 Manufactured No

110 Each 0.0000 1 1

D350-607-143

Automatic Lid Opener Installation

**

B 81572 sp.

AN3-16A Purchased No

110 Each 135.0000 2 2

AN3-16A

Bolt

**

sp

Location

Loc Qty

Loc Code

ST352

135

117441

49

118628

36

120986

50

2x

AN4-13A Purchased No

110 Each 1,361.000 2 2

AN4-13A

Bolt

**

sp 12-04/16

Location

Loc Qty

Loc Code

ST357

1361

119449

59

120187

402

120422

500

120770

400

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

March-15-12 12:44:19 PM

Work Order ID: 81563

81563

Parent Item: D350-607-047A

D350-607-047A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN4-22A Purchased No

110 Each

206.0000

5

5

AN4-22A

Bolt

**

SP

Location

Loc Qty

Loc Code

ST359

206

116419

49

117313

7

~~118628~~

100

120930

50

SP

AN5-17A Purchased No

110 Each

80.0000

4

4

AN5-17A

Bolt

**

m12181 SP

Location

Loc Qty

Loc Code

ST338

80

117872

42

120498

38

MS20600-AD4W3 Purchased No

110 Each

1,304.000

2

2

MS20600-AD4W3

Cherry Rivets

**

SP 12-04-16

Location

Loc Qty

Loc Code

ST321

1171

111636

36

117505

6

117601

27

118626

602

120308

500

WA018

133

107939

133

2x

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-15-12 12:44:20 PM

Work Order ID: 81563

81563

Parent Item: D350-607-047A

D350-607-047A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

3,024.000

14

14

NAS1149D0463.J

Washer

**

14
M/12/255 SP

Location

Loc Qty

Loc Code

ST297

2000

121011

2000

ST298

1024

116805

0

118384

25

119097

169

120644

830

NAS1149D0563J

Purchased

No

110

Each

2,990.000

4

4

NAS1149D0563.J

Washer

**

SP

Location

Loc Qty

Loc Code

ST298

2990

118206

19

118614

494

119546

2000

119717

477

14X

NAS1149D0832J per FIN

NAS1149D0832J

Purchased

No

110

Each

274.0000

2

2

NAS1149D0832.J

Washer

**

SP 12-04-16.

Location

Loc Qty

Loc Code

ST298

274

112608

74

113237

100

114348

100

M 120422

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-15-12 12:44:20 PM

Work Order ID: 81563

81563

Parent Item: D350-607-047A

D350-607-047A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1515H4

Purchased

No

110

Each

171.0000

2

2

NAS1515H4

Washer

**

m121060 sp.

Location

Loc Qty

Loc Code

ST277

171

116169

3

117460

1

117735

3

118078

48

118612

9

120120

50

120498

7

120770

50

MS21042L3

Purchased

No

110

Each

3,091.000

2

2

MS21042L3

Nut

**

sp 12-04-16.

Location

Loc Qty

Loc Code

ST300

3091

117441

16

117885

32

118451

5

118927

3

119017

2862

119075

173

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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March-15-12 12:44:20 PM

Work Order ID: 81563

81563

Parent Item: D350-607-047A

D350-607-047A

Parent Item Name: Heli-Utility-Basket (Automatic Lid Opener)

Start Date: 15/03/2012

Required Date: 13/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

5,531.000

7

7

MS21042I 4

**

Nut

Location

Loc Qty

Loc Code

ST300

5531

117441

51

117601

157

118451

133

119017

200

119075

2990

121011

2000

7x

MS21042L5

Purchased

No

110

Each

1,598.000

4

4

MS21042I 5

**

Nut

Location

Loc Qty

Loc Code

ST300

1598

116105

5

116548

43

117611

42

118179

8

119109

1500

4x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

6.2 D350-607-045/-045A/-047/-047A HELI-UTILITY-BASKET™

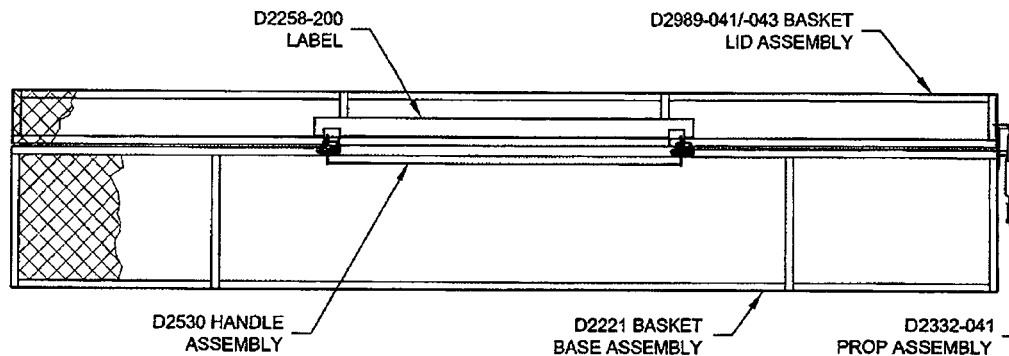
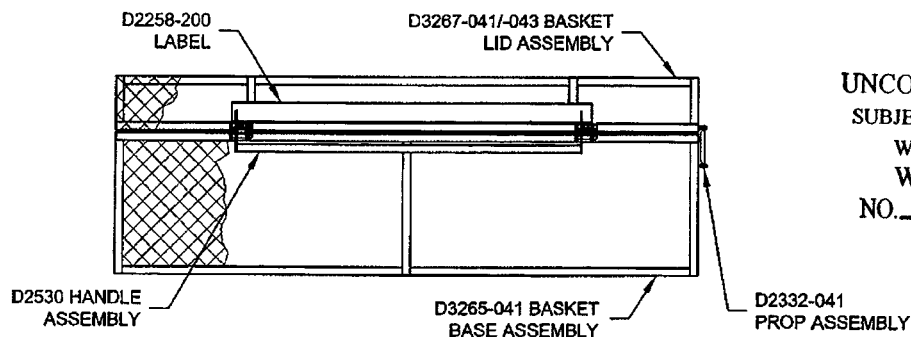
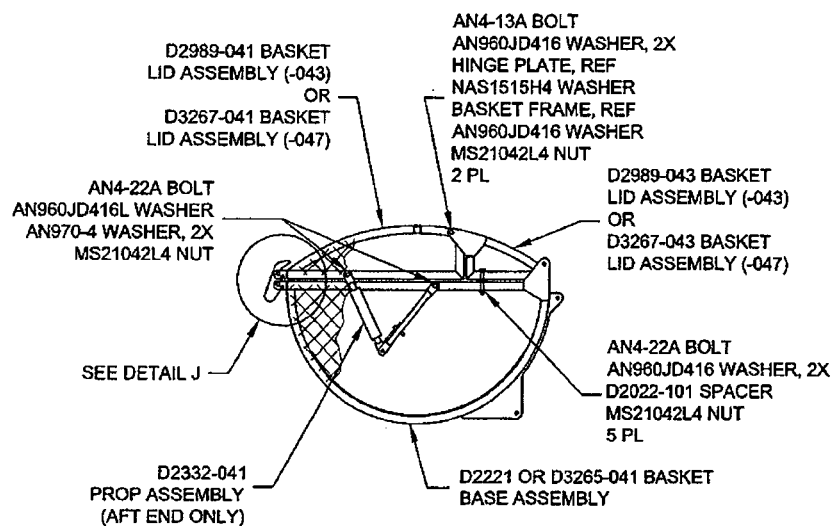
Qty -045	Qty -045A	Qty -047	Qty -047A	Qty -241	Part Number	Description
X					D350-607-045	HELI-UTILITY-BASKET
	X				D350-607-045A	HELI-UTILITY-BASKET
		X			D350-607-047	HELI-UTILITY-BASKET
			X		D350-607-047A	HELI-UTILITY-BASKET
1	1	1	1	X	D350-607-241	BASKET CLAMP KIT INSTALLATION
2	2	5	5		D2022-101	SPACER
				4	D2230-1	LUG
				4	D2230-3	CLAMP
1	1	1	1		D2258-200	LABEL
1	1	1	1		D2324	STRUT
1		1			D2332-041	PROP ASSEMBLY
1	1	1	1		D2530	HANDLE WELDMENT
2	2	2	2		D2535	SPRING
2	2	2	2		D2537	BUSHING
				8	D2732-030	RUBBER CUSHION
2	2	2	2		D2931	BUMPER
1	1	1	1		D3265-041	BASKET BASE ASSEMBLY
1	1				D3266-041	BASKET LID ASSEMBLY
		1	1		D3267-041	BASKET LID (OUTSIDE)
		1	1		D3267-043	BASKET LID (INSIDE)
			1		D350-607-143	AUTOMATIC LID OPENER INSTL
	1				D350-607-145	AUTOMATIC LID OPENER INSTL
2	2	2	2		AN3-16A	BOLT
2	2				AN4-7A	BOLT
5	5	5	5		AN4-12A	BOLT
		2	2		AN4-13A	BOLT
				8	AN4-15A	BOLT
1		7	5		AN4-22A	BOLT
1					AN4-24A	BOLT
4	4	4	4		AN5-17A	BOLT
2	2	2	2		MS20600AD4W3	RIVET (OR CR9163-4-3)
12	12	24	24	16	NAS1149D0463J	WASHER (OR AN960JD416)
2		2			NAS1149D0416J	WASHER (OR AN960JD416L)
4	4	4	4		NAS1149D0563J	WASHER (OR AN960JD516)
2	2	2	2		NAS1149DN832J	WASHER (AN960JD8)
		2	2		NAS1515H4	WASHER
4		4			AN970-4	WASHER
2	2	2	2		MS21042L3	NUT (OR MS21042-3)
9	7	14	12	8	MS21042L4	NUT (OR MS21042-4)
4	4	4	4		MS21042L5	NUT (OR MS21042-5)

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Revision: A

Date: 10.03.10

**D350-607-043 HELI-UTILITY- BASKET™****D350-607-047 HELI-UTILITY- BASKET™****VIEW C-C**
PROP ARM DETAIL**Figure 6- Basket Replacement Parts**

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Revision: **A**
Date: 10.03.10

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 21563
MLJ

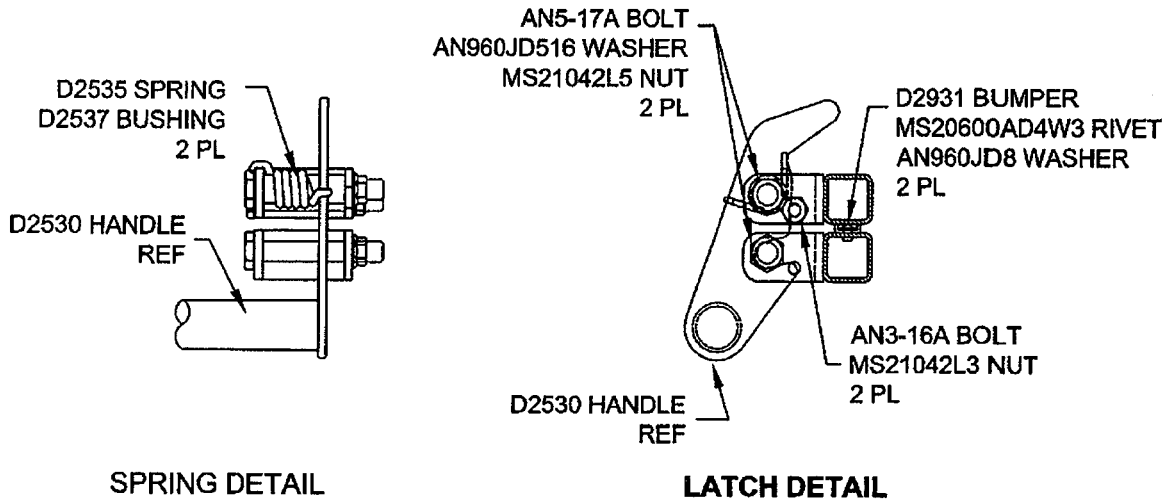
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

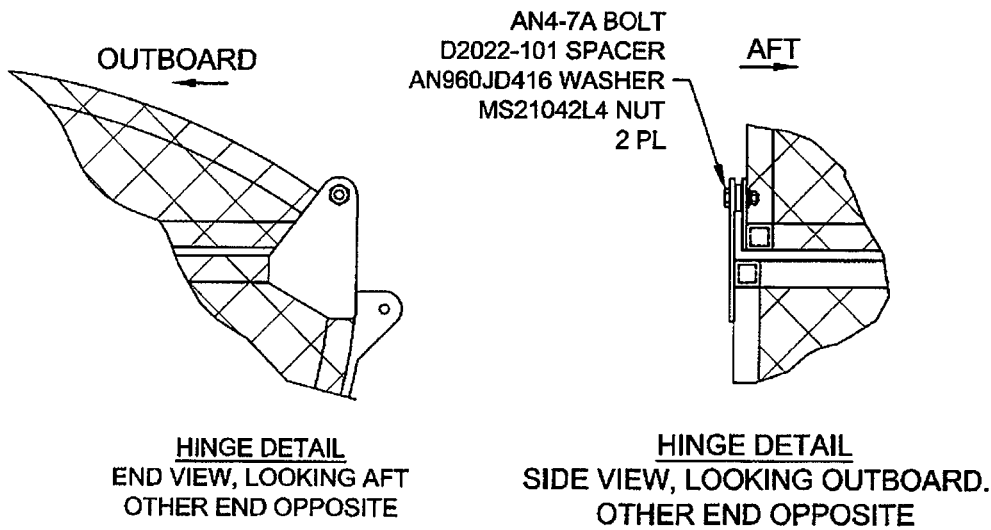
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL J:
HANDLE WELDMENT



DETAIL H:
HINGE

Figure 7 – Basket Replacement Parts

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Revision: **A**
Date: 10.03.10

81503

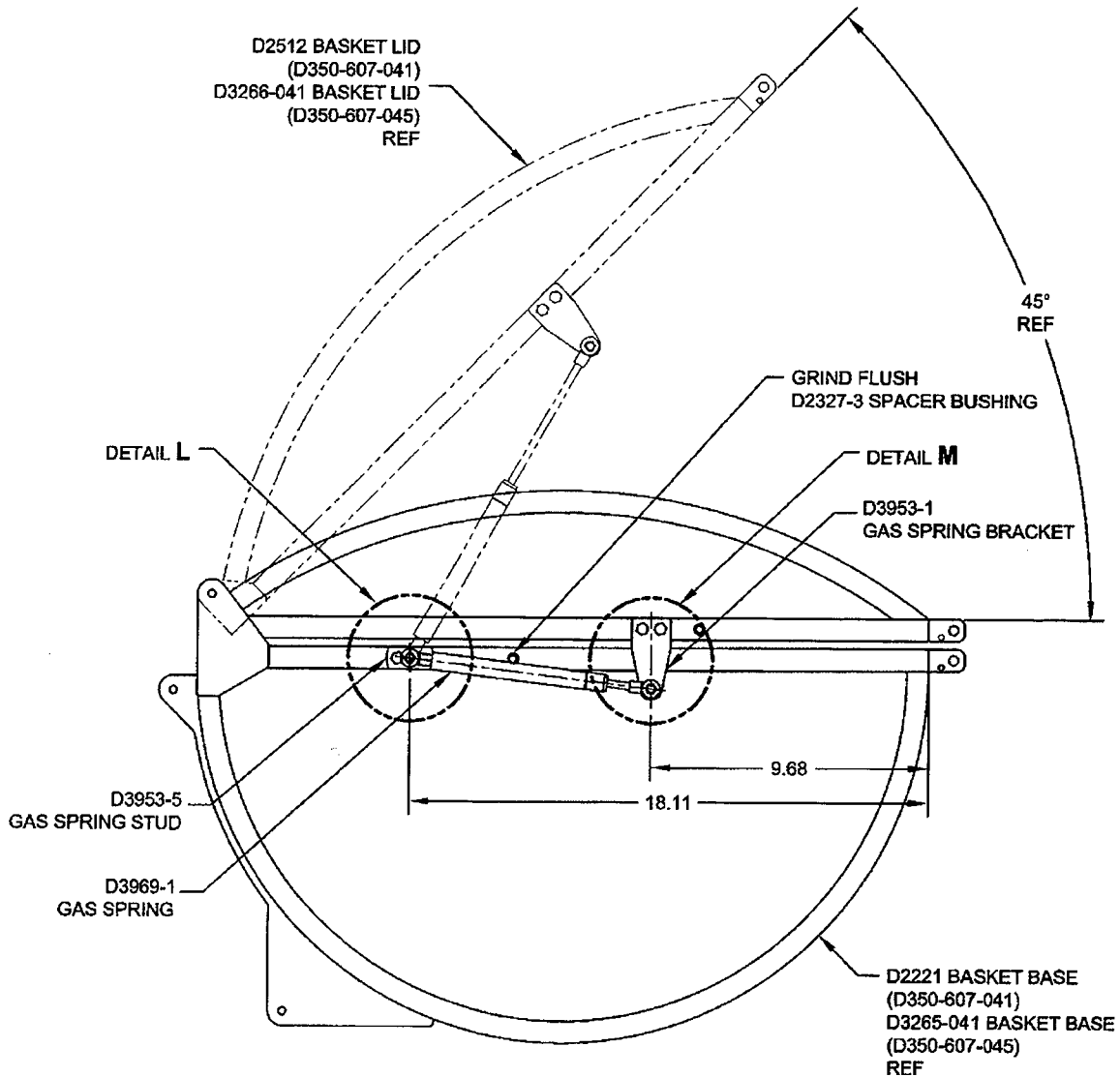
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D350-607-141 AUTOMATIC LID OPENER INSTALLATION

(BOTH ENDS)

D350-607-145 AUTOMATIC LID OPENER INSTALLATION

(1 END ONLY)

Figure 8a – Automatic Lid Opener Installation

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Revision: **A**

Date: 10.03.10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries